

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010795**Date Inspected:** 06-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW tack welding of lifting eyes onto a 900mm plate marked thusly: A709M HPS 485WT2, CO199, GGL-JZGT-1255 and also contained weld WSD1-TL5-2E/F-24B. Welder was identified as 053310. ZPMC QC was identified as CWI You Qi Guo (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Shao Hai Long, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4112.

FCAW welding of weld joint WSTL4-2H/L-93 located inside PCMK west tower, lift 4, skin A to top of 131M double diaphragm. Welder was identified as 040609. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P5-F.

FCAW welding of weld joint WSTL4-2F/L-134 located inside PCMK west tower, lift 4, skin A to top of 123M double diaphragm. Welder was identified as 053486. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P5-F.

Bay 10

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint NSTL4-3L/L-4B located inside PCMK north tower, lift 4, skin A to skin B. Welder was identified as 050289. ZPMC QC was identified as CWI Tu Jun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Hao, who was not a CWI. The welding variables recorded by QC2 's assistant appeared to comply with WPS-B-T-3211-Tc-U4b-1.

SMAW tack welding of lifting eyes onto plates marked only as P169, P171, P172. Welder was identified as 054069. ZPMC QC was identified as QC2. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
